
वस्त्रादि — जिल्दसाज़ी का कपड़ा — विशिष्टि
(पहला पुनरीक्षण)

**Textiles — Book Binding Cloth —
Specification**
(*First Revision*)

ICS 59.080.30

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भारतीय मानक ब्यूरो
BUREAU OF INDIAN STANDARDS
मानक भवन, 9 बहादुरशाह ज़फर मार्ग, नई दिल्ली -110002
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG
NEW DELHI-110002
www.bis.gov.in www.standardsbis.in

FOREWORD

This Indian Standard (First Revision) was adopted by the Bureau of Indian Standards, after the draft finalized by the Man-Made Fibres, Cotton and their Products Sectional Committee had been approved by the Textiles Division Council.

This standard was originally published in 1983 and has now been revised to incorporate the following changes:

1. All Amendments have been incorporated
2. BIS certification marking clause has been modified.
3. References to Indian Standards have been updated.
4. Sampling plan has been modified.

The composition of the Committee responsible for the formulation of this standard is given in Annex B.

For the purpose of deciding whether a particular requirement of this standard is complied with, the final value, observed or calculated, expressing the result of a test or analysis shall be rounded off in accordance with IS 2 : 2022 'Rules for rounding off numerical values (*second revision*)'. The number of significant places retained in the rounded off value should be the same as that of the specified value in this standard.

Indian Standard
TEXTILES — BOOK BINDING CLOTH —
SPECIFICATION
(First Revision)

1 SCOPE

1.1 This standard prescribes the constructional details and other requirements of cotton cloth used for book binding. The cloth may be scoured or dyed.

1.2 This standard does not specify the general appearance, feel, etc, of the cloth (*see also 4.3*).

2 REFERENCES

The standards listed in Annex A contain provisions which, through reference in this text, constitute provisions of this standard. At the time of publication, the editions indicated were valid. All standards are subject to revision and parties to agreements based on this standard are encouraged to investigate the possibility of applying the most recent editions of these standards.

3 MANUFACTURE

3.1 Yarn — The cotton yarn used in the manufacture of the cloth shall be satisfactory in evenness and reasonably free from neps and other spinning defects.

3.2 Cloth — The cloth shall be sized and coated with a suitable coating material which shall admit printing and gold embossing. The layer of coating should be even, allowing silk-screen printing to be clean, not smudgy. The quality of coating should be such that ink in the course of serigraphy does not spread the letters retaining their forms. The coating shall not crack nor peel off when the cloth is folded.

3.2.1 The cloth shall adhere firmly to the surface, edges, sharp and round corners of the strawboard cover of the books when bound with binding paste on the uncoated side.

3.2.2 The cloth when visually examined shall be reasonably free from spinning, weaving and processing defects.

4 REQUIREMENTS

4.1 The constructional particulars of the cloth shall conform to those given in Table 1, excepting the count of warp and weft yarns which has been given only for guidance.

4.2 The colour fastness rating of the dyed cloth and other requirements of the cloth shall conform to those given in Table 2.

Table 1 Constructional Particulars of Book Binding Cloth

(Clause 4.1)

Sl No.	Approximate Count of Yarn (Cotton Count (tex))		Ends per cm	Picks per cm	Mass g/m ²	Breaking Strength on 5 × 20 cm Strip, N (kgf), <i>Min</i>		Bursting Strength, kg/m ² , <i>Min</i>	Length, m, <i>Min</i>	Width, cm	Weave
	Warp	Weft				Warp	Weft				
(1)	(2)	(3)	(4)	(5)	(6)	(7)	(8)	(9)	(10)	(11)	(12)
i)	18s (33)	18s (33)	18	13	160	360 (35)	200 (20)	5	20	100 or as agreed	Plain
Tolerance, Percent	—	—	± 5	± 5	± 5	—	—	—	—	± 2	—
Method of Test	—	—	←IS 1963→	IS 1964		← IS 1969 (Part 1) →	IS 1966 (Part 1)		← IS 1954 →		Visual

Table 2 Chemical Requirements of Book Binding Cloth
(Clause 4.2)

Sl No.	Characteristic	Requirement	Method of Test
(1)	(2)	(3)	(4)
i)	Colour fastness to light (Dyed fabrics only) (<i>see</i> Note)	4 or better	IS/ISO 105-B01 or IS/ISO 105-B02
ii)	Colour fastness to washing (Dyed fabrics only)	4 or better	IS/ISO 105-C10 [Test Number A (1)]
iii)	Coating content (calculated on the mass of the uncoated fabric), percent, <i>Min</i>	60	Boiling in water for 2 hours and washing with soap.
iv)	Pliability	The coating shall not show any tendency to crack.	The cloth after Conditioning for 2 h at 0°C is folded double and pressed by hand on a flat surface.

NOTE — In case of dispute, the colour fastness to light shall be determined by the method prescribed in IS/ISO 105-B01.

4.3 Sealed Sample — If in order to illustrate or specify the undeterminable characteristics such as general appearance, lustre, feel, and shade of the cloth, a sample has been agreed upon and sealed, the supply shall be in conformity with the sample in such respects.

4.3.1 The custody of the sealed sample shall be a matter of prior agreement between the buyer and the seller.

5 MARKING

5.1 Each roll of cloth shall have a label marked with the following information:

- a) Name of the material;
- b) Length and width of the piece;

- c) Manufacturer's name, initials or trade-mark; if any; and
- d) Year of manufacture.

5.1.1 The label shall be pasted on the roll in such a way that the rolls cannot be bent without tearing the label.

5.1.1 BIS Certification Marking

The product(s) conforming to the requirements of this standard may be certified as per the conformity assessment schemes under the provisions of the *Bureau of Indian Standards Act, 2016* and the Rules and Regulations framed thereunder, and the product(s) may be marked with the Standard Mark.

6 PACKING

6.1 The cloth shall be packed in roll form. Each roll shall be tightly and evenly wound, free from wrinkles, on a wooden rod (*see* Note) with the coated surface facing inside. Each roll shall be covered completely by a polythene sheet or kraft paper. The two ends of the polythene sheet or kraft paper shall be gummed or tied with cotton tape.

NOTE — The wooden rod shall be of 2 cm diameter and have a length at least 2 cm more than the width of the cloth.

7 SAMPLING

7.1 The lot shall consist of all the bales/packs of cloth delivered to a buyer against one despatch note.

7.2 Unless otherwise sampling plan is specified in the contract or order, the sampling plan as given in Table 3 may be used for inspecting and testing of cloth against this standard. The number of rolls to be selected from the lot for assessing manufacture and workmanship (*see* 3.1 and 3.2) and testing width, ends, picks and weight shall be as per col 2 of Table 3. The number of test specimens to be selected for other tests shall be in accordance with col 4 of Table 3. To ensure the randomness of selection, IS 4905 may be followed.

7.3 Criteria for Conformity

The lot shall be declared conforming to the requirements of this standard if the total number of defective samples does not exceed the permissible numbers given in col 3 or col 5 of Table 3 as applicable.

Table 3 Sampling Plan for Book Binding Cloth
(Clause 7.2 and 7.3)

Sl No.	Lot Size	Sample Size	Permissible No. of Defectives Samples	Sub-Sample Size (to be drawn from sample)	Permissible No. of Defectives Sub-Samples
(1)	(2)	(3)	(4)	(5)	(6)
i)	2 to 25	3	0	3	0
ii)	26 to 90	13	1	3	0
iii)	91 to 150	20	2	13	1
iv)	151 to 280	32	3	13	1
v)	281 to 500	50	5	20	1
vi)	501 to 1 200	80	7	32	2
vii)	1 201 and above	125	10	50	3

NOTE — If sample size equals or exceeds lot size, carry out 100 percent inspection.

ANNEX A

(Clause 2)

LIST OF REFERRED INDIAN STANDARDS

<i>IS No.</i>	<i>Title</i>	<i>IS No.</i>	<i>Title</i>
1954 : 1990	Determination of length and width of woven fabrics — Methods (<i>second revision</i>)	4905 : 2015	Random sampling and randomization procedures (<i>first revision</i>)
1963 : 1981	Methods for determination of threads per unit length in woven fabrics (<i>second revision</i>)	IS/ISO 105-B01:2014	Textiles — Tests for colour fastness — Part B01 Colour fastness to light: Daylight
1964 : 2001	Textiles — Methods for determination of mass per unit length and mass per unit area of fabrics (<i>second revision</i>)	IS/ISO 105-B02:2014	Textiles — Tests for colour fastness — Part B02 Colour fastness to artificial light: Xenon arc fading lamp test
1966 (Part 1) : 2009	Textiles — Bursting properties of fabrics — Determination of bursting strength and bursting distension Part 1 Hydraulic method (<i>second revision</i>)	IS/ISO 105-C10:2006	Textiles — Tests for colour fastness Part C10 Colour fastness to washing with soap or soap and soda
1969 (Part 1) : 2018	Textiles — Tensile properties of fabrics — Part 1 Determination of maximum force and elongation at maximum force using the strip method (<i>fourth revision</i>)		

ANNEX B

(Foreword)

COMMITTEE COMPOSITION

Man-Made Fibers, Cotton and their Products Sectional Committee,
TXD 31

<i>Organization</i>	<i>Representative(s)</i>
ICAR – Central Institute for Research on Cotton Technology, Mumbai	DR P. K. MANDHYAN (<i>Chairman</i>)
Ahmedabad Textile Industry's Research Association, Ahmedabad	SHRIMATI DEEPALI PLAWAT SHRI JIGAR DAVE (<i>Alternate</i>)
Association of Synthetic Fibre Industries, New Delhi	SHRI M. S. VERMA
AYM Syntex Ltd, Dadra and Nagar Haveli	SHRI ARNAB SAMANTHA SHRI SAUGATA DAS (<i>Alternate</i>)
Confederation of Indian Textile Industry, New Delhi	SHRI D. K. NAIR SHRI SHAJU MANGALAM (<i>Alternate</i>)
Consumer Guidance Society of India, Mumbai	DR SITARAM DIXIT DR M. S. KAMATH (<i>Alternate</i>)
Cotton Association of India, Mumbai	SECRETARY
Defence Materials and Stores Research and Development Establishment, Kanpur	SHRI ASHOK KUMAR YADAV SHRI BISWA RANJAN DAS (<i>Alternate</i>)
Grasim Industries Limited, Vadodara	SHRI AJAY SARDANA DR ROHITASVA KUMAR (<i>Alternate</i>)
ICAR – Central Institute for Research on Cotton Technology, Mumbai	DR SENTHIL KUMAR DR A ARPUTHARAJ (<i>Alternate</i>)
JCT Limited, Phagwara	SHRI KHUSHWINDER SINGH DHILLON SHRI ARWINDER SINGH (<i>Alternate</i>)
North India Textile Mills Association, Chandigarh	SHRI SANJAY GARG SHRI SIDHARTHA KHANNA (<i>Alternate</i>)
Northern India Textile Research Association, Ghaziabad	SHRI SANJEEV SHUKLA SHRIMATI NEHA KAPIL (<i>Alternate</i>)
Office of Textile Commissioner, Mumbai	SHRI SOURABH KULKARNI SHRI PRANAV PARASHAR (<i>Alternate</i>)

<i>Organization</i>	<i>Representative(s)</i>
Reliance Industries Limited, Mumbai	SHRI AJAY GUPTA SHRI KESHAV P PAAREEK (<i>Alternate</i>)
Textile Committee, Mumbai	SHRI J. D. BARMAN SHRI P. N. S. SIVAKUMAR (<i>Alternate</i>)
The Bombay Textile Research Association, Mumbai	SHRI R. A. SHAIKH SHRIMATI PRAGATI KULKARNI (<i>Alternate</i>)
The Cotton Corporation of India Ltd, Navi Mumbai	SHRI P. N. PILLEWAR SHRI V. K. SINHA (<i>Alternate</i>)
The Cotton Textile Export Promotion Council, Mumbai	SHRI SIDDARTHA RAJGOPAL
The Southern India Mills Association, Coimbatore	SHRI D. SURESH ANAND KUMAR
The Synthetic & Rayon Textile Export Promotion Council, Mumbai	SHRI S. BALARAJU
The Synthetic and Art Silk Mills Research Association, Mumbai	DR MANISHA MATHUR SHRIMATI ASHWINI A. SUDAM (<i>Alternate</i>)
Veermata Jijabai Technological Institute, Mumbai	DR (SMT) SURANJANA GANGOPADHYAY
In personal capacity (<i>D-618, Maruti Paradise, Sector - 15, CBD-Belapur, Navi Mumbai - 400614.Maharashtra.</i>)	SHRI A. SATHEESAN
BIS Directorate General	SHRI J. K. GUPTA, Scientist E and Head (Textiles) [Representing Director General (<i>Ex-officio</i>)]

Member Secretary
SHRI MAYUR KATIYAR
Scientist 'B' (Textiles), BIS

Bureau of Indian Standards

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This Indian Standard has been developed from Doc No.: TXD 31(18067).

Amendments Issued Since Publication

Amend No.	Date of Issue	Text Affected

BUREAU OF INDIAN STANDARDS

Headquarters:

Manak Bhavan, 9 Bahadur Shah Zafar Marg, New Delhi 110002
Telephones: 2323 0131, 2323 3375, 2323 9402

Website: www.bis.gov.in

Regional Offices:

Telephones

Central:	601/A Konnectus Tower-I, 6 th Floor DMRC Building, Bhavbhuti Marg, New Delhi 110 002	2323 7617
Eastern:	8 th Floor, Plot No. 7/7 & 7/8, CP Block, Sector V Salt Lake, Kolkata 700091	236 7012, 2320 9474
Northern:	Plot No. 4A, Sector 27-B, Madhya Marg Chandigarh 160 019	265 0206, 265 0290
Southern:	C I T Campus, IV Cross Road, Taramani Chennai 600 113	2254 1442, 2254 1216
Western:	Plot No. E-9, Road No. 8, MIDC, Andheri (East) Mumbai 400 093	28218093

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